

Vydyne® PF004XXP

polyamide 6



Vydyne PF004XXP is a 20% glass fiber reinforced PA6 for injection molded applications.

General				
Regional Availability	• North America • Europe			
Agency Rating	• ISO, 1043 PA6 GF20			
Appearance	• Natural Color			
Forms	• Pellets			
Processing Method	• Injection Molding			
Physical	dry	cond.	Unit	Test Standard
Density	1.27	-	g/cm ³	ISO 1183
Mechanical	dry	cond.	Unit	Test Standard
Tensile Modulus (23°C)	6200	-	MPa	ISO 527-2
Tensile Stress (Yield, 23°C)	106	-	MPa	ISO 527-2
Tensile Strain (Yield, 23°C)	3	-	%	ISO 527-2
Flexural Modulus (23°C)	4600	-	MPa	ISO 178
Flexural Strength (23°C)	158	-	MPa	ISO 178
Impact	dry	cond.	Unit	Test Standard
Notched Izod Impact Strength, +23°C	7	-	kJ/m ²	ISO 180/1A
Thermal	dry	cond.	Unit	Test Standard
Heat Deflection Temperature, 1.80 MPa, Unannealed	165	-	°C	ISO 75-2/A
Electrical	Value		Unit	Test Standard
Comparative Tracking Index (3.00 mm)	500		V	IEC 60112
Flammability	Value		Unit	Test Standard
Glow Wire Flammability Index 1.60 mm	650		°C	IEC 60695-2-12
Injection	Value		Unit	
Drying Temperature	75 - 85		°C	
Drying Time	4 - 6		h	
Suggested Max Moisture	0.2		%	
Rear Temperature	230 - 240		°C	

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Middle Temperature	240 - 250	°C
Front Temperature	240 - 270	°C
Processing (Melt) Temperature	240 - 270	°C
Mold Temperature	60 - 80	°C

